

Danner, Dale

From: Danner, Dale
Sent: Monday, December 18, 2000 4:27 PM
To: Bristol, II Ronald H.
Cc: Millner, Thomas L.; Russo, Al; Golemboski, Matt R.; Snedeker, Jim; Franz, Scott; Diaz, Danny
Subject: M/710 DAT/T&P Exit Letter

Ron,
Attached find the M/710 test exit letter and subject conditions we discussed via telecon last Friday. Please let me know if you require further.
Dale



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REMINGTON ARMS COMPANY, INC.

RESEARCH & DEVELOPMENT TECHNOLOGY CENTER

315 W. RING ROAD

ELIZABETHTOWN, KENTUCKY 42701-9318

(270) 769-7600 FAX (270) 737-9576

Remington Arms Company, Inc.
Ron H. Bristol II
Post Office Box 700
Madison, NC 27025

VIA EMAIL: BRISTOLRH@REMINGTON.COM

The Test and Measurement organization within the Elizabethtown Research and Development facility formally supports exit from both Design Acceptance and Trial and Pilot testing of the M/710 Bolt Action Firearm (configured in .3006 caliber with Bushnell 763942 riflescope) subject to the following issues and conditions:

1. Prior to product shipment from Mayfield a Design Transmittal **must** occur to formally establish component dimensional parameters. All product must conform to these parameters or a written deviation from design must be obtained from the Design team.
2. Mayfield **must** address the continuing problem of the Firing Pin Head loosening from the Firing Pin Body. Test recommends a statistically significant audit of product by Mayfield to confirm resolution of the issue.
3. Mayfield **must** re-examine the process which allowed two firearms to be swapped between boxes. This issue is driven by BATF serial number tracking requirements.
4. Several issues continue to exist which Test reasonably believes will result in customer dissatisfaction. These issues have no test objective criteria associated with them so Test has no basis to withhold ship approval. Consequently, Test supports ship contingent on Marketing approval of these issues.
 - Magazine Box Bottom Retention – Latest data from Series C product indicates that 17% of the product will experience this problem within the first 100 rounds of use. During the Series C test the earliest occurrence was at round 49.
 - Magazine Box Difficult to Remove – This problem was pervasive on the Series C product and may potentially contribute to the Bottom Retention issue above.
 - Bolt Stop Detent Freedom – Latest data from Series C product suggests that 20% of the product will experience a loosening of the detent lever during the first 100 rounds of use.
 - Bushnell Scope – Data from Series B product suggests that approximately 8% of the product will experience scope issues early in life. Bushnell has confirmed that an assembly issue exists with the scope.
 - Take Down Screw Torque – Data from Series C product indicates that 37% of the product will have some loosening of the takedown screws. Further, data obtained by

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Mayfield and reported on 20NOV00 supports the conclusion that some loss of torque does occur. While this does not constitute a safety issue consumers may potentially notice the phenomena.

Test further recommends that these issues be resolved as quickly as possible via design/process change to limit negative customer exposure.

5. Test recommends that Mayfield re-examine process controls and limits around the Trigger Pull Force via a process capability study. Data obtained in Etown from the Series C product indicated that some product was slightly below the low pull specification of 4.00 pounds. All product however was in excess of the SAAMI specified minimum of 3.00 pounds.

Elizabethtown stands ready to assist should you determine that additional audits of the product are required.

With Kind Regards,

Dale R. Danner
Director of Research and Technology
Remington Arms Company, Inc.

cc: D.D. Diaz
S.R. Franz
M.R. Golemboski
T.L. Millner
A.D. Russo
J.R. Snedeker

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